<b>Work Ord</b> August-21-12 1.	er ID 89080 07:19 PM			Page 1								
Item ID: Revision ID: Item Name:	D412-698-012 Cabin Door Roller,	RH		)*	Setup	Start Stop		S1* S2*				
	9/04/12 <b>Sta</b>	ort Qty: 3.00 q'd Qty: 3.00	*3* *3*		Cust Item I Customer:	D:						
Approvals:	Process Plan:QC:	MLJ	Date: 12/08/2	22 Tooling: SPC (Y/N):		ate:			Run	Start Stop		R1* R2*
Sequence ID/ Work Center II		eration ecription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qt		Reject Number	Insp. Stamp
Draw Nbr	Revision	Nbr										······································
IIN D412-698	Rev E											
*1 \\n^* DC  Document Control	DOC	CUMENT CONTRO  Memo  Photocopy b		0.00 0.00 per PPP D412-698-012 CF	17/0/7			#	da	MC	5 12-	10-18
110 <b>*110*</b> Packaging	Pick	: Kit Memo		0.00				<u>3</u>				12/10/17
Packaging  120  *120* QC  QC  Quality Control	QC4	4- 100% Inspect kits <b>Memo</b>	for completeness	0.00	40, /2/w/2	1		(+)	b)			

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												DQA:	Date:	
NCR:	Yes	/ No					WORK ORDER NON-C	O	NFORM	AANCE / UPI	DATE	04.01	Data	•
												QA Closed:	Date:	
Vork Ord	er:						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
							Rework	1		Skid-tube	Crosstube	]	Water Jet	Engineering
Part	No.					1	Scrap			Machining	Small Fab	4	d. Eng. Coor.	Quality
							Use-as-is		noforming	Finishing	Rec/Stor	e/Packaging	Other	
NCR	No.						Work Order Update Large Fab Composi					J	Supplier	
Root					Desc	crip	ption of work order update Initial Action					Sign &		
Cause		Date	Step	Qty		0	r Non-conformance Chief Eng Description					Date	Verification	QC Inspector
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	_	Bending			1		Bend		Grain		_	Ovalized		Pressure/Forced
	L	Centre No	ot Conce	ntric to O	ı/S		BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks					Broken/Damaged	amaged Inspection Incomplete				Part Incorre	ct	Weld
		Crushed/	Crimped.	-			Burrs Instructions Incomplete/Unclear				Unclear	Part Lost/M	issing	Wrong Stock Pulled
	L	Cuffs					Contamination Maintenance					Part Moved		
	L	Heat Trea	it				Countersink		Mislabe	led		Positioned \	Wrong	_
		Inspection	n Strip in	Tube			Cut Too Short		Misread	d		Power Loss/	'Surge	Other
		Ripples in	Bend				Drill Holes	Offset						
		Torque W	/aves in E	Extrusion			Drawing	[	Out of (	Calibration				
	Г	Turning S	eanence	<b>,</b>	1		Finish		Out of	Sequence				

Outside Dimensions

Wave/Twist in Tube

Folio

Work Ord August-21-12		080		*890	8N*						Page 2
Item ID: Revision ID:	D412-698-0	12		*N9000401			100	)*	Setup Star	*N	S1*
Item Name:	Cabin Door F	Roller, RH							Stop	*N	S2*
Start Date: Required Date	9/04/12 : 9/04/12	Start Qty: 3.00 Req'd Qty: 3.00	*3* *3*		Cust Item I Customer:	D:					
Approvals:		an:	Date:	Tooling: _ SPC (Y/N):		ate:		]	Run Star Stop		R1* R2*
Sequence ID/ Work Center I	(D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp.
*130* Packaging Packaging		Packaging  Memo  Identify and Location:	pack for shipping as per	0.00	აგ			L		12)	16/225
140 *1 <b>4\O</b> *		QC21- Final Inspection		0.00					12/1	0 33	
Quality Control		Мето								M	F 10-72

Vec	1	No
	Vec	Yes /

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:	

									QA Closed:	Date:	
Work Orde	er:				DISPOSITION			AGAINST DE	PARTMENT	PROCESS	Ť
Part N	No				Rework Scrap Use-as-is Work Order Update	( B	Skid-tube Crosstube Water Jet Engine Machining Small Fab Prod. Eng. Coor. Qu Thermoforming Finishing Rec/Store/Packaging Composite Supplier				
Root				Descri	ption of work order update	Initial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling								,	'		
Operator											
Material											
Setup											
Other				•	•						
Process											
Supplier											
Training		ļ									
Unapproved											
	·····				F	AULT CATE	GORY	·			
Landi	ng Gear			_	General			<b>,</b>	1	<b></b>	
	Bending			<u> </u>	Bend	Grain			Ovalized		Pressure/Forced
	Centre No	ot Concer	ntric to (	o/s	BOM/Route	Hardwa			Over/Under	tolerance	Temperature/Cure
-	Cracks				Broken/Damaged	<b>—</b>	ion Incomplete		Part Incorred	<del></del>	Weld
	Crushed/	Crimped.		_	Burrs	<b>——</b>	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	Mainte			Part Moved		
	Heat Trea			<u> </u>	Countersink	Mislabe			Positioned V		7
	Inspectio	-	Tube	<u> </u>	Cut Too Short	Misrea	d		Power Loss/	Surge	Other
	Ripples in			ļ	Drill Holes	Offset					
	Torque W			י <u> </u>	Drawing	Out of Calibration					
	Turning S			<b> </b>	Finish	$\vdash$	Sequence				
	Wave/Tw	ist in Tub	oe		Folio	Outside	Dimensions				

August-21-12 1:07:19 PM

Work Order ID:

89080

Parent Item:

D412-698-012

Parent Item Name:

Cabin Door Roller, RH

**Start Date:** 9/04/12

Required Date: 9/04/12

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP Rev:C04.02.26Change Qty of D3121-141 & remove D3121-145 from Step 1,3KJ/DS IPP Rev:D 08-01-28 change to rev D ECN 1104 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-IVII  Bracket Assembly		Manufactured	No			110	Each	0.0000	3	9	8830	197	10 2 gs
D3121-144  Bracket Assembly  D3137-043		Manufactured	No			110	Each	0.0000		4923	JB		5
D313)2043		Manufactured	No			110	Each	2.0000		238	JB	·	
Bracket Assembly				Location		Loc Qty	<u>L</u>	oc Code			-		•
· ·				ST235B		2							
				7973	4	2							^
D3183=044  Bracket Assembly		Manufactured	No			110	Each	8.0000	1 + 89	7/18	JB	·	S
43				<b>Location</b>		Loc Qty	<u>L</u>	oc Code			•		
				ST		-4							
				ST235B		12			2×85	7996			400
				8599	6	8							
03199-1 Bracket		Manufactured	No			110	Each	56.0000	9	822 <mark>7</mark>	78	<u>j.</u>	2/10/17
				Location		Loc Qty	<u>L</u>	oc Code			•		
				ST		24							
				8546	57	24							
				ST236		37							
				7861		2							
				8668	32	30							
				ST236A		-5							

												DQA:	Date:		
NCR:	⁄es	/ No					WORK ORDER NON-C	O	VFOR	MANCE / UPDATE				•	
						_	**************************************	_				QA Closed:	Date:		
Nork Ord	er:						DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part i	No.						Rework Scrap Use-as-is			Machining Sm. noforming Fir	sstube all Fab		Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other	
NCR I	No.					١	Work Order Update			Large Fab Com	posite		Supplier	J LJ	
Root					Desc	rip	tion of work order update		nitial	Action		Sign &			
Cause		Date	Step	Qty		o	r Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector	
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napproved				<u> </u>											
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Landi	ng (	Gear					General		_			-		_	
	L	Bending					Bend	L	Grain			Ovalized		Pressure/Forced	
		Centre No	ot Concer	ntric to	o/s		BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
		Cracks					Broken/Damaged		Inspect	on Incomplete		Part Incorred	ct	Weld	
		Crushed/	Crimped.				Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled	
	Г	Cuffs			Γ		Contamination	Г	Mainte	nance		Part Moved			
		Heat Treat Countersink					Countersink		Mislabe	led		Positioned V	Vrong		
		Inspection	n Strip in	Tube					Misread	i		Power Loss/	Surge	Other	
	Ripples in Bend Drill Holes					Offset		<b></b>	<b>-</b>	_	•				
	Torque Waves in Extrusion Drawing						Out of	Calibration							
	Turning Sequence Finish						Out of Sequence								

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

## **Picklist Print**

August-21-12 1:07:19 PM

Page 2

Work Order ID:

89080

Parent Item:

D412-698-012

Parent Item Name:

Cabin Door Roller, RH

**Start Date:** 9/04/12

Required Date: 9/04/12

Start Qty: 3.00

Required Qty: 3.00

D3202-0

Manufactured

No

110

13.0000

Loc Code

Each

19375 3

gB 12/10/1

Cover

 Location
 Loc Qty

 ST241A
 13

 70294
 2

 83506
 11

2 x 83506

											DQA:	Date:	•		
NCR: Y	'es	/ No				WORK ORDER NON-C	CON	IFORM	ANCE / UPD	ATE	•		1		
											QA Closed:	Date:			
Nork Orde	\r·					DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	ł		
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Part N	lo.					Scrap			Machining	Small Fab	Proc	l. Eng. Coor.	Quality		
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NCR N	Ю.					Work Order Update	J		Large Fab	Composite		Supplier			
Root					Descri	liption of work order update		nitial	Actio	on	Sign &				
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		Bending				Bend		Grain			Ovalized		Pressure/Forced		
		Centre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure		
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	:t	Weld		
		Crushed/0	Crimped.			Burrs		Instruct	ions Incomplete/Ur	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled		
		Cuffs				Contamination		Mainte	nance		Part Moved				
		Heat Trea	t			Countersink		Mislabe	eled		Positioned V	/rong	_		
ę I	Inspection Strip in Tube Cut Too Short				Cut Too Short		Misread	i		Power Loss/	Surge	Other			
	Ripples in Bend					Drill Holes		Offset							
	Torque Waves in Extrusion Drawing					Drawing		Out of (	Calibration						
	Turning Sequence Finish							Out of s	Sequence						
	Wave/Twist in Tube					Folio		Outside	Dimensions						

## 6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012}	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X	-012-	-0.0	-017	0.0		D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
	<del>  ^</del>	X				D412-698-013	DOOR HANDLE KIT
	<del>                                     </del>		Х			D412-698-017	REPLACEMENT DOOR TRACK KIT
	<del> </del>			X		D412-698-019	BEARING OVERHAUL KIT
					Х	D412-698-021	REPLACEMENT SHIM KIT
							DDAGUET AGGENELY
3	73					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	11					D3121-144	BRACKET ASSEMBLY
1	<b>L</b> 1_					D3137-043	BRACKET ASSEMBLY
1			-			-D3183-043	BRACKET ASSEMBLY
	٢ 1					D3183-044 <	-BRACKET ASSEMBLY
9	[՟_ <u>Ղ</u> 9		9			D3199-1	BRACKET
1	11_		1			-D3202-1	COVER
	<del> </del>	4	_			D3203-1	HANDLE
		1				D3220-041	DOUBLER
	i	1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
	1				2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8			<del>                                     </del>	AN960JD416L	WASHER
	<u> </u>	8	<u> </u>	<b>!</b>		MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
	<del>                                     </del>		T	1		MS24694-S101	SCREW